

**Work Order ID 58829**

Wednesday, May 19, 2010 1:03:23 PM



Page 1

Item ID: D3639-2

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 5/19/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-5-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D3639	Rev A
-------	-------

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

2024 . 050

Memo

0.00

map not pulled

B10-6-2

(8)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

B10-6-2

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

S. volokha

(76)

(77)

Pto →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3639-2 PAR #: Fault Category: Prod eng card. NCR: Yes No DQA: Date: 10-06-02  
 Resolution: SCU420 Disposition: SCU420 QA: N/C Closed: Date: 10/06/02

NCR: 58829		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/06/02	# 120	Pans Qty +2 parts with tabs. cut in the tabs 0.098" holes. Re. Lens in tool with 15 cm outside of hole.	Initial SCU420	-Script Destroy no replace w/o needs Qty x6 # 8 were made. - Pan check dwell	HS 10-6-2	S 10/06/02	SCU420	10/06/02
		Program error. Pressure from moving to point to point	Initial SCU420	-Fix Program-	JL 10-10-02	S 10/06/02	SCU420	10/06/02

\*NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 58829**

Wednesday, May 19, 2010 1:03:23 PM



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Item ID: D3639-2

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 5/19/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

170



QC

Quality Control

Operation  
Description

QC3- Inspect Part Finish

Set Up/  
Run Hours

0.00

Draw  
Number

Rev.

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location: SI244A

0.00

190



QC

Quality Control

Memo

0.00

X6 BB 10/06/08

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

X6 10/06/08 J

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, May 19, 2010 1:03:27 PM

Page 1

Work Order ID: 58829



Parent Item: D3639-2



Parent Item Name: Doubler

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM  
remove c'sink DD 10.04.13 verified by:EC

Verified By:EC

IPP Rev:B

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.050						100	sf	33.9947	0.239	2.2	BB 10-6-2	

2024-T3 .050 sheet

Location	Loc Qty	Loc Code
MAT22	33.9947	
111381	30.9	
112291	2.7	
113189	0.3947	112291

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	58829
Description: Doubler	Part Number:	D3639-2
Inspection Dwg: D3639	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	BS	Audited by:	S	Prototype Approval:	N/A
Date:	10-6-2	Date:	10/06/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	JL

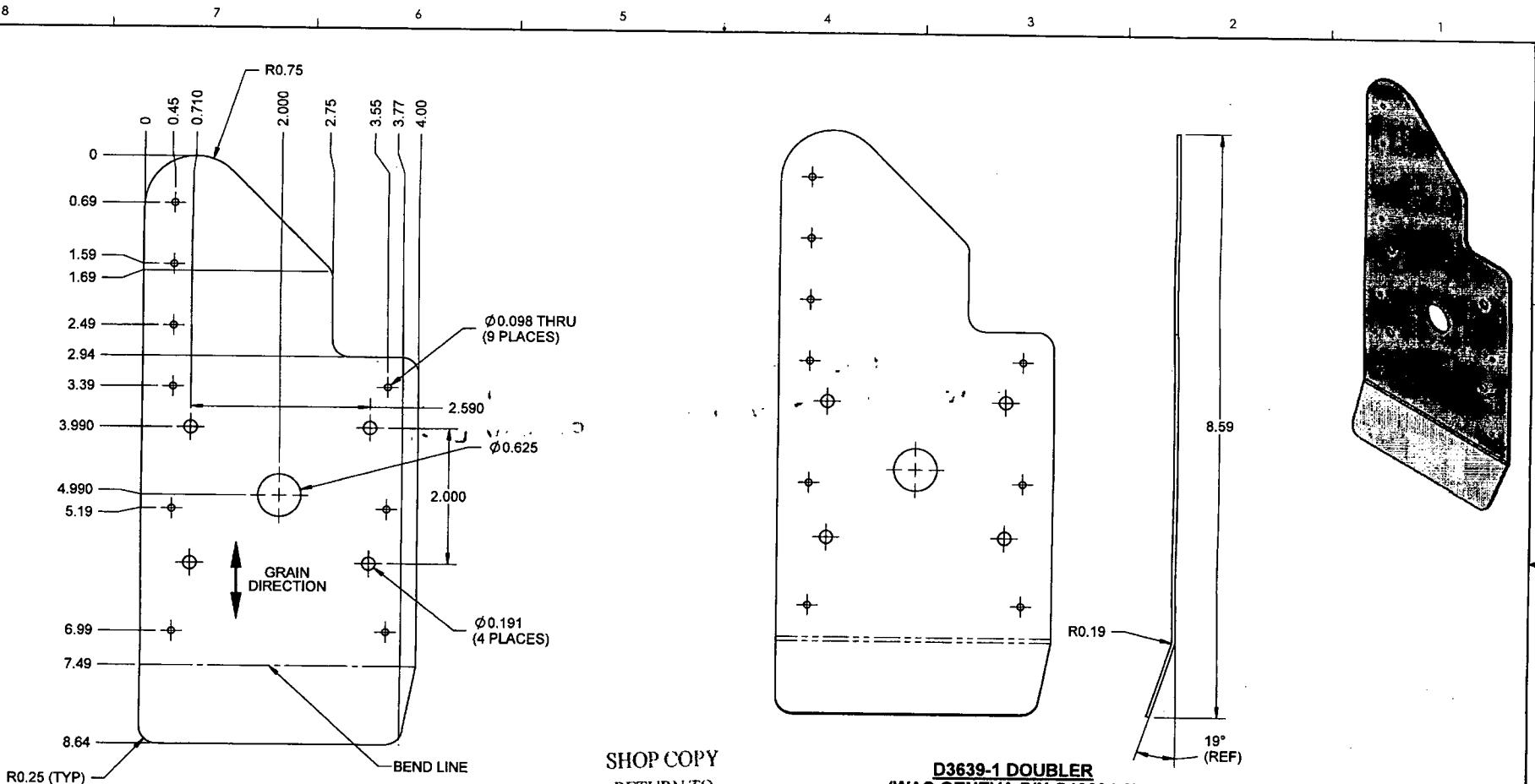
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3639-1F FLAT PATTERN  
(D3639-2F OPPOSITE)**

**A** NOTES:  
 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037  
 (REF DART SPEC M2024T3S.050)  
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.14 lbs

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT

WITHOUT NOTICE  
 WORK ORDER  
 NO. 38829  
07-05-19

**D3639-1 DOUBLER  
 (WAS GENEVA P/N G10604-3)**  
**D3639-2 OPPOSITE  
 (WAS GENEVA P/N G10604-6)**

**RELEASED**  
 07-07-27

A	NEW ISSUE: REPLACES G10604		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	<i>CE</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN			PORT HADLOCK, WA	
CHECKED	<i>BS</i>		DRAWING NO.	REV. A
MFG. APPR.	<i>BS</i>		D3639	SHEET 1 OF 2
APPROVED	<i>BS</i>		TITLE	SCALE
DE APPR.	<i>BS</i>		DOUBLER	2:3
DATE	07.07.27		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

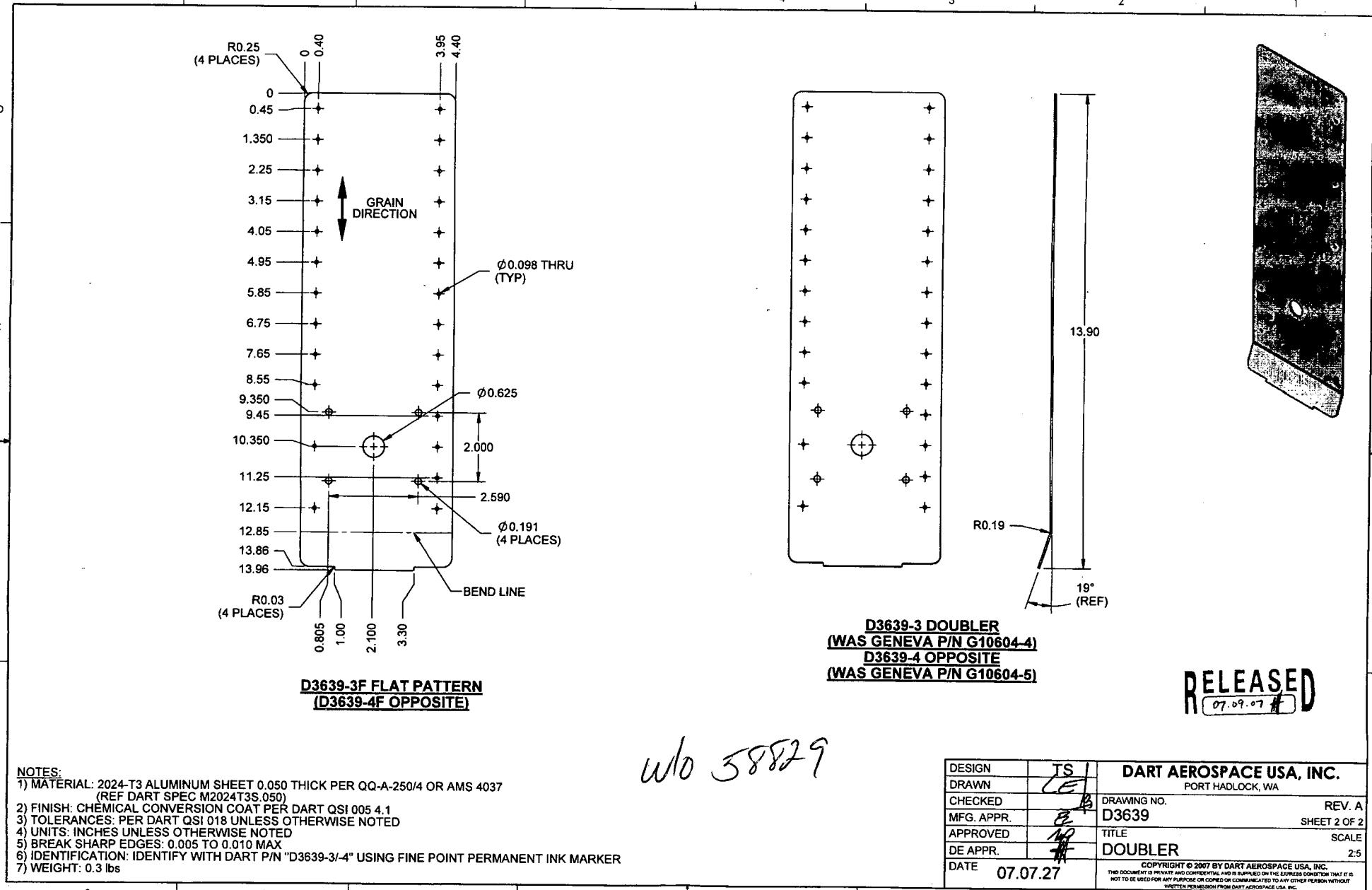
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
DATE	07.07.27	

DRAWING NO. D3639 REV. A  
SHEET 2 OF 2  
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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